

Work Order ID 82547

Monday, April 02, 2012 3:43:50 PM

82547

Page 1

Item ID: D3697-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube Assembly
 Start Date: 4/2/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/17/2012 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: Date: 204-2 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3697	Rev B								
130	Large Fab	0.00							
130									
Large Fab	Memo	0.00							
Large Fab	1- cut at 72.00" as per dwg D3697								
	2- form and trim tube as per dwg D3697 using DT90033-deburr								
	3-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using DT9003 welding jig								
	4-drill holes in tube in 5 pls as per dwg D3697								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									

EL 12-4-4 (X)

1 0 BE12-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82547

Monday, April 02, 2012 3:43:50 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 4/2/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/17/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

Identify as per dwg & Stock Location: ST 241A

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

1x _____ Sp
12-04-10

12/4/10

Q12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 02, 2012 3:43:54 PM

Page 1

Work Order ID: 82547

82547

Parent Item: D3697-041

D3697-041

Parent Item Name: Tube Assembly

Start Date: 4/2/2012

Required Date: 4/17/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3697-3

Manufactured

No

130

Each

5.0000

1

1

D3697-3

Support Plate, LH

**

EL 12-4-4

Location

Loc Qty

Loc Code

WA023

5

50386

5

1

D3697-4

Manufactured

No

130

Each

5.0000

1

1

D3697-4

Support Plate, RH

**

EL 12-4-4

Location

Loc Qty

Loc Code

WA023

5

59681

5

1

D3797-1

Manufactured

No

130

Each

4.0000

1

1

D3797-1

Ground Plate

**

EL 12-4-4

Location

Loc Qty

Loc Code

ST241A

4

74313

4

1

M6061T6T0.375W.049

Purchased

No

130

f

72.0000

6

6.315789

M6061T6T0.375W.049

6061-T6 RD Tube .375 x.049W

**

EL 12-4-3

Location

Loc Qty

Loc Code

MAT014

72

109000

12

116720

12

119160

48

6

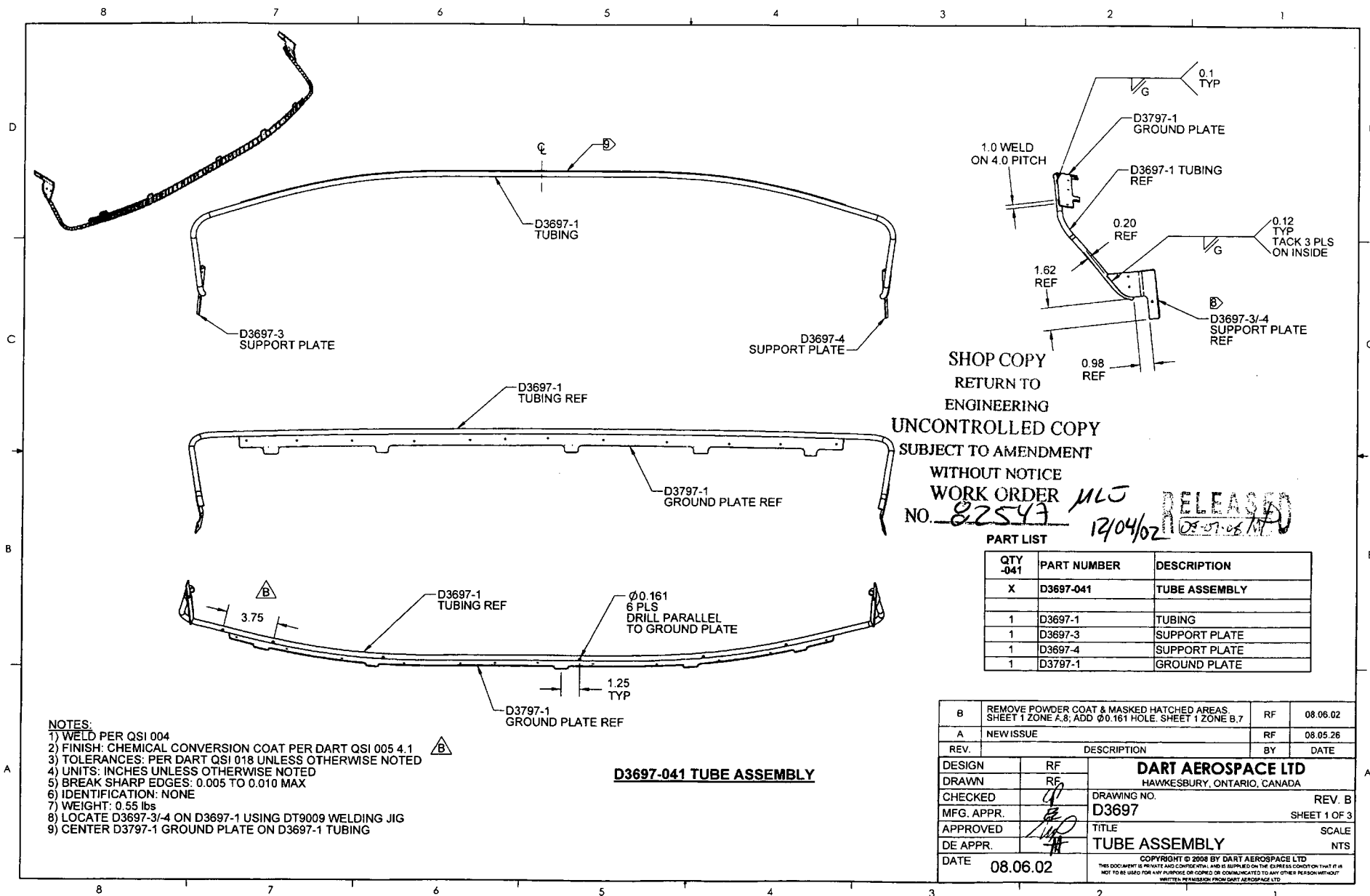
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

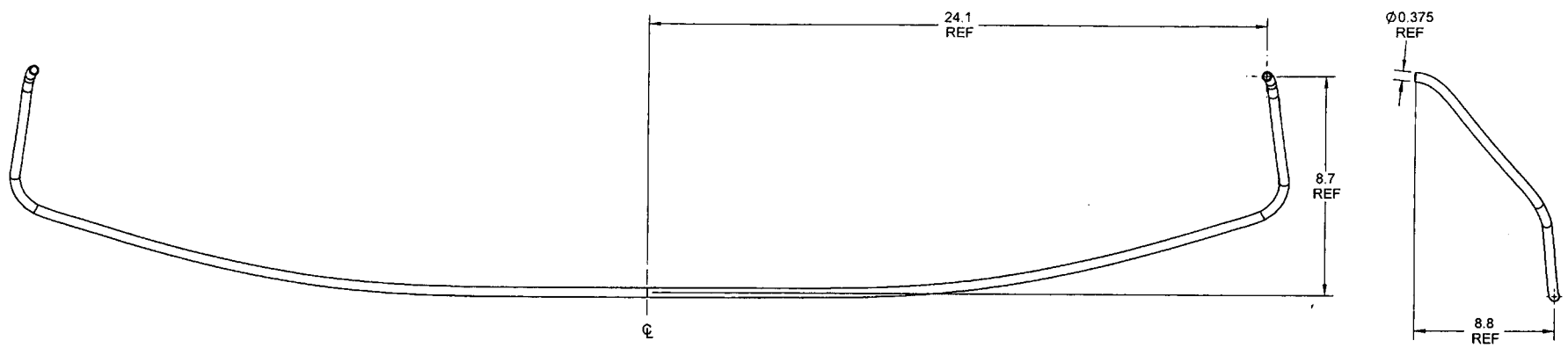
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82547







D3697-1 TUBING

RELEASED
08.07.08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WV-T-700/6) ALUMINUM TUBING $\phi 0.375 \times 0.049$ WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3697	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		TUBE ASSEMBLY	
DATE	08.06.02	NTS	
<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

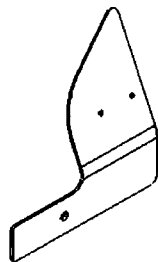
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

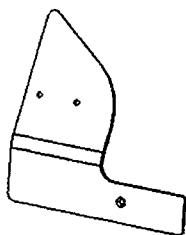
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

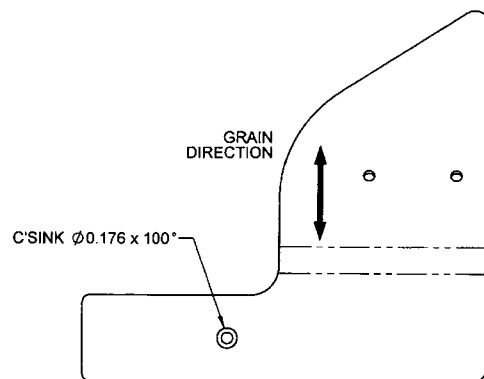
NOTE: Date & initial all entries



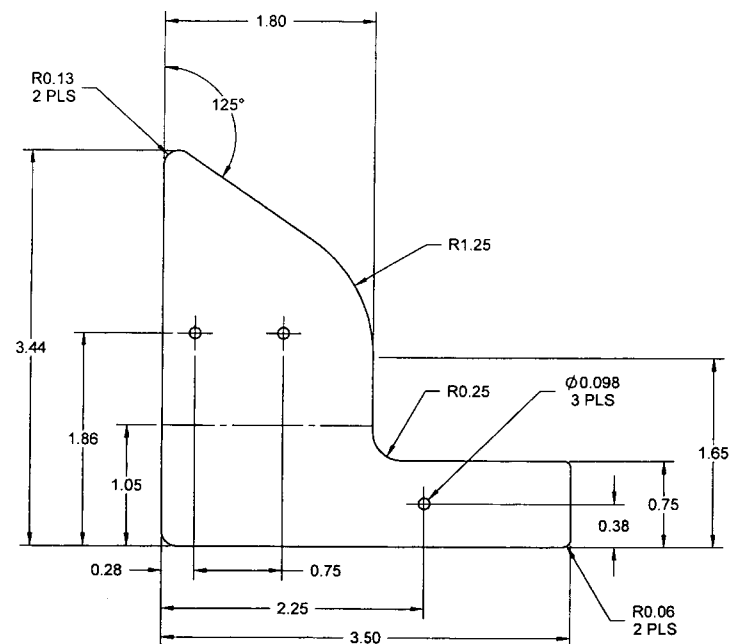
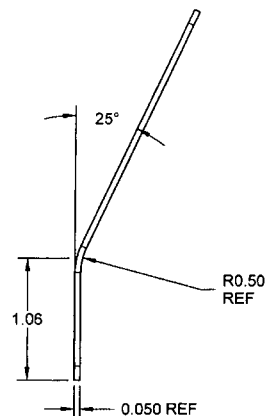
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3697	REV. B
MFG. APPR.		TITLE TUBE ASSEMBLY	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	08.06.02	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08-07-08/17

82547

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries